

This Page Is Inserted by IFW Operations
and is not a part of the Official Record

BEST AVAILABLE IMAGES

Defective images within this document are accurate representations of the original documents submitted by the applicant.

Defects in the images may include (but are not limited to):

- BLACK BORDERS
- TEXT CUT OFF AT TOP, BOTTOM OR SIDES
- FADED TEXT
- ILLEGIBLE TEXT
- SKEWED/SLANTED IMAGES
- COLORED PHOTOS
- BLACK OR VERY BLACK AND WHITE DARK PHOTOS
- GRAY SCALE DOCUMENTS

IMAGES ARE BEST AVAILABLE COPY.

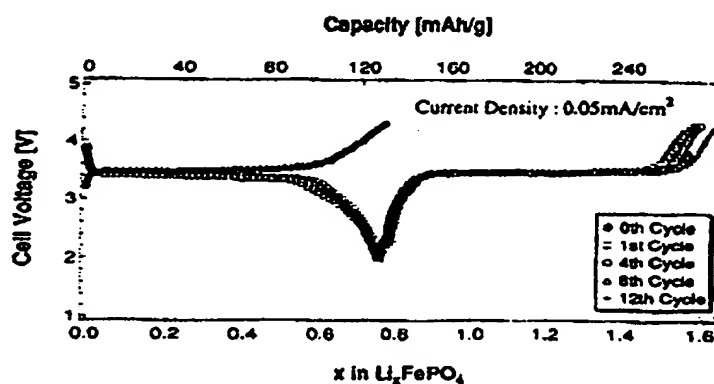
**As rescanning documents *will not* correct images,
please do not report the images to the
Image Problem Mailbox.**



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : H01M 4/58, C01B 25/26	A1	(11) International Publication Number: WO 97/40541 (43) International Publication Date: 30 October 1997 (30.10.97)
(21) International Application Number: PCT/US97/06671 (22) International Filing Date: 23 April 1997 (23.04.97) (30) Priority Data: 60/016,060 23 April 1996 (23.04.96) US 60/032,346 4 December 1996 (04.12.96) US (71) Applicant: BOARD OF REGENTS, THE UNIVERSITY OF TEXAS SYSTEM [US/US]; 201 West 7th Street, Austin, TX 78701 (US). (72) Inventors: GOODENOUGH, John, B.; 4311 Greystone Drive, Austin, TX 78731 (US). PADHI, Akshaya; 2910 Medical Arts #303, Austin, TX 78705 (US). NANJUNDASWAMY, K., S.; 3110 Red River Street #203, Austin, TX 78705 (US). MASQUELIER, Christian; Université Paris - XI Orsay, Laboratoire De Chimie Des Solides Ura-cnrs 446, Bâtiment 414, F-91405 Orsay Cédex (FR). (74) Agent: BOWLES, Teresa, J.; Arnold, White & Durkee, P.O. Box 4433, Houston, TX 77210 (US).		(81) Designated States: CA, JP, European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE). Published <i>With international search report.</i> <i>Before the expiration of the time limit for amending the claims and to be republished in the event of the receipt of amendments.</i>

(54) Title: CATHODE MATERIALS FOR SECONDARY (RECHARGEABLE) LITHIUM BATTERIES

**(57) Abstract**

The invention relates to materials for use as electrodes in an alkali-ion secondary (rechargeable) battery, particularly a lithium-ion battery. The invention provides transition-metal compounds having the ordered-olivine or the rhombohedral NASICON structure and the polyanion $(\text{PO}_4)^{3-}$ as at least one constituent for use as electrode material for alkali-ion rechargeable batteries.

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece			TR	Turkey
BG	Bulgaria	HU	Hungary	ML	Mali	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MN	Mongolia	UA	Ukraine
BR	Brazil	IL	Israel	MR	Mauritania	UG	Uganda
BY	Belarus	IS	Iceland	MW	Malawi	US	United States of America
CA	Canada	IT	Italy	MX	Mexico	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NE	Niger	VN	Viet Nam
CG	Congo	KE	Kenya	NL	Netherlands	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NO	Norway	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	NZ	New Zealand		
CM	Cameroon			PL	Poland		
CN	China	KR	Republic of Korea	PT	Portugal		
CU	Cuba	KZ	Kazakstan	RO	Romania		
CZ	Czech Republic	LC	Saint Lucia	RU	Russian Federation		
DE	Germany	LI	Liechtenstein	SD	Sudan		
DK	Denmark	LK	Sri Lanka	SE	Sweden		
EE	Estonia	LR	Liberia	SG	Singapore		

DESCRIPTION

CATHODE MATERIALS FOR SECONDARY (RECHARGEABLE) LITHIUM BATTERIES

BACKGROUND OF THE INVENTION

This application is a continuation-in-art of provisional patent application No. 60/032,346 filed December 4, 1996, and a continuation-in-part of provisional patent application No. 60/016,060, filed April 23, 1996. The entire text of each of the above-referenced disclosures is specifically incorporated by reference herein without disclaimer. The Robert A. Welch Foundation, Houston, Texas, supported research related to the present invention.

1. Field of the Invention

The present invention relates to secondary (rechargeable) alkali-ion batteries. More specifically, the invention relates to materials for use as electrodes for an alkali-ion battery. The invention provides transition-metal compounds having the ordered olivine or the rhombohedral NASICON structure and containing the polyanion $(\text{PO}_4)^{3-}$ as at least one constituent for use as electrode material for alkali-ion rechargeable batteries.

2. Description of the Related Art

Present-day lithium batteries use a solid reductant as the anode and a solid oxidant as the cathode. On discharge, the metallic anode supplies Li^+ ions to the Li^+ -ion electrolyte and electrons to the external circuit. The cathode is typically an electronically conducting host into which Li^+ ions are inserted reversibly from the electrolyte as a guest species and charge-compensated by electrons from the external circuit. The chemical reactions at the anode and cathode of a lithium secondary battery must be reversible. On charge, removal of electrons from the cathode by an external field releases Li^+ ions back to the electrolyte to restore the parent host structure, and the addition of electrons to the anode by the external field attracts charge-compensating Li^+ ions back into the anode to restore it to its original composition.

Present-day rechargeable lithium-ion batteries use a coke material into which lithium is inserted reversibly as the anode and a layered or framework transition-metal oxide is used as the cathode host material (Nishi *et al.*, U.S. Patent 4,959,281). Layered oxides using Co and/or Ni are expensive and may degrade due to the incorporation of unwanted species from the electrolyte. Oxides such as $\text{Li}_{1\pm x}[\text{Mn}_2]\text{O}_4$, which has the $[\text{M}_2]\text{O}_4$ spinel framework, provide strong bonding in three dimensions and an interconnected interstitial space for lithium insertion. However, the small size of the O^{2-} ion restricts the free volume available to the Li^+ ions, which limits the power capability of the electrodes. Although substitution of a larger S^{2-} ion for the O^{2-} ion increases the free volume available to the Li^+ ions, it also reduces the output voltage of an elementary cell.

A host material that will provide a larger free volume for Li^+ -ion motion in the interstitial space would allow realization of a higher lithium-ion conductivity σ_{Li} , and hence higher power densities. An oxide is needed for output voltage, and hence higher energy density. An inexpensive, non-polluting transition-metal atom would make the battery environmentally benign.

SUMMARY OF THE INVENTION

The present invention meets these goals more adequately than previously known secondary battery cathode materials by providing oxides containing larger tetrahedral oxide polyanions forming 3D framework host structures with octahedral-site transition-metal oxidant cations, such as iron, that are environmentally benign.

The present invention provides electrode material for a rechargeable electrochemical cell comprising an anode, a cathode and an electrolyte. The cell may additionally include an electrode separator. As used herein, "electrochemical cell" refers not only to the building block, or internal portion, of a battery but is also meant to refer to a battery in general. Although either the cathode or the anode may comprise the material of the invention, the material will preferably be useful in the cathode.

Generally, in one aspect, the invention provides an ordered olivine compound having the general formula LiMPO_4 , where M is at least one first row transition-metal cation. The alkali ion Li^+ may be inserted/extracted reversibly from/to the electrolyte of

the battery to/from the interstitial space of the host MPO_4 framework of the ordered-olivine structure as the transition-metal M cation (or combination of cations) is reduced/oxidized by charge-compensating electrons supplied/removed by the external circuit of the battery in, for a cathode material, a discharge/charge cycle. In particular, M will preferably be Mn, Fe, Co, Ti, Ni or a combination thereof. Examples of combinations of the transition-metals for use as the substituent M include, but are not limited to, $\text{Fe}_{1-x}\text{Mn}_x$, and $\text{Fe}_{1-x}\text{Ti}_x$, where $0 < x < 1$.

Preferred formulas for the ordered olivine electrode compounds of the invention include, but are not limited to LiFePO_4 , LiMnPO_4 , LiCoPO_4 , LiNiPO_4 , and mixed transition-metal compounds such as $\text{Li}_{1-2x}\text{Fe}_{1-x}\text{Ti}_x\text{PO}_4$ or $\text{LiFe}_{1-x}\text{Mn}_x\text{PO}_4$, where $0 < x < 1$. However, it will be understood by one of skill in the art that other compounds having the general formula LiMPO_4 and an ordered olivine structure are included within the scope of the invention.

The electrode materials of the general formula LiMPO_4 described herein typically have an ordered olivine structure having a plurality of planes defined by zigzag chains and linear chains, where the M atoms occupy the zigzag chains of octahedra and the Li atoms occupy the linear chains of alternate planes of octahedral sites.

In another aspect, the invention provides electrode materials for a rechargeable electrochemical cell comprising an anode, a cathode and an electrolyte, with or without an electrode separator, where the electrode materials comprise a rhombohedral NASICON material having the formula $\text{Y}_x\text{M}_2(\text{PO}_4)_3$, where $0 \leq x \leq 5$. Preferably, the compounds of the invention will be useful as the cathode of a rechargeable electrochemical cell. The alkali ion Y may be inserted from the electrolyte of the battery to the interstitial space of the rhombohedral $\text{M}_2(\text{XO}_4)_3$ NASICON host framework as the transition-metal M cation (or combination of cations) is reduced by charge-compensating electrons supplied by the external circuit of the battery during discharge with the reverse process occurring during charge of the battery. While it is contemplated that the materials of the invention may consist of either a single rhombohedral phase or two phases, e.g. orthorhombic and monoclinic, the materials are preferably single-phase rhombohedral NASICON compounds. Generally, M will be at least one first-row

transition-metal cation and Y will be Li or Na. In preferred compounds, M will be Fe, V, Mn, or Ti and Y will be Li.

Redox energies of the host M cations can be varied by a suitable choice of the XO_4 polyanion, where X is taken from Si, P, As, or S and the structure may contain a combination of such polyanions. Tuning of the redox energies allows optimization of the battery voltage with respect to the electrolyte used in the battery. The invention replaces the oxide ion O^{2-} of conventional cathode materials by a polyanion $(\text{XO}_4)^{m-}$ to take advantage of (1) the larger size of the polyanion, which can enlarge the free volume of the host interstitial space available to the alkali ions, and (2) the covalent X-O bonding, which stabilizes the redox energies of the M cations with M-O-X bonding so as to create acceptable open-circuit voltages V_{oc} with environmentally benign $\text{Fe}^{3+}/\text{Fe}^{2+}$ and/or $\text{Ti}^{4+}/\text{Ti}^{3+}$ or $\text{V}^{4+}/\text{V}^{3+}$ redox couples.

Preferred formulas for the rhombohedral NASICON electrode compounds of the invention include, but are not limited to those having the formula $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$, $\text{Li}_{2+x}\text{FeTi}(\text{PO}_4)_3$, $\text{Li}_x\text{TiNb}(\text{PO}_4)_3$, and $\text{Li}_{1+x}\text{FeNb}(\text{PO}_4)_3$, where $0 < x < 2$. It will be understood by one of skill in the art that Na may be substituted for Li in any of the above compounds to provide cathode materials for a Na ion rechargeable battery. For example, one may employ $\text{Na}_{3+x}\text{Fe}_2(\text{PO}_4)_3$, $\text{Na}_{2+x}\text{FeTi}(\text{PO}_4)_3$, $\text{Na}_x\text{TiNb}(\text{PO}_4)_3$ or $\text{Na}_{1+x}\text{FeNb}(\text{PO}_4)_3$, where $0 < x < 2$, in a Na ion rechargeable battery. In this aspect, Na^+ is the working ion and the anode and electrolyte comprise a Na compound.

Compounds of the invention having the rhombohedral NASICON structure form a framework of MO_6 octahedra sharing all of their corners with XO_4 tetrahedra (X = Si, P, As, or S), the XO_4 tetrahedra sharing all of their corners with octahedra. Pairs of MO_6 octahedra have faces bridged by three XO_4 tetrahedra to form "lantern" units aligned parallel to the hexagonal c-axis (the rhombohedral [111] direction), each of these XO_4 tetrahedra bridging to two different "lantern" units. The Li^+ or Na^+ ions occupy the interstitial space within the $\text{M}_2(\text{XO}_4)_3$ framework. Generally, $\text{Y}_x\text{M}_2(\text{XO}_4)_3$ compounds with the rhombohedral NASICON framework may be prepared by solid-state reaction of stoichiometric proportions of the Y, M, and XO_4 groups for the desired valence of the M cation. Where Y is Li, the compounds may be prepared indirectly from the Na analog by

ion exchange of Li^+ for Na^+ ions in a molten LiNO_3 bath at 300°C . For example, rhombohedral $\text{LiTi}_2(\text{PO}_4)_3$ may be prepared from intimate mixtures of Li_2CO_3 or $\text{LiOH}\cdot\text{H}_2\text{O}$, TiO_2 , and $\text{NH}_4\text{H}_2\text{PO}_4\cdot\text{H}_2\text{O}$ calcined in air at 200°C to eliminate H_2O and CO_2 followed by heating in air for 24 hours near 850°C and a further heating for 24 hours near 950°C . However, preparation of $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$ by a similar solid-state reaction gives the undesired monoclinic framework. To obtain the rhombohedral form, it is necessary to prepare rhombohedral $\text{Na}_3\text{Fe}_2(\text{PO}_4)_3$ by solid-state reaction of NaCO_3 , $\text{Fe}\{\text{CH}_2\text{COOH}\}_2$ and $\text{NH}_4\text{H}_2\text{PO}_4\cdot\text{H}_2\text{O}$, for example. The rhombohedral form of $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$ is then obtained at 300°C by ion exchange of Li^+ for Na^+ in a bath of molten LiNO_3 . It will be understood by one of skill in the art that the rhombohedral Na compounds will be useful as cathode materials in rechargeable Na ion batteries.

In another aspect of the invention, the rhombohedral NASICON electrode compounds may have the general formula $\text{Y}_x\text{M}_2(\text{PO}_4)_y(\text{XO}_4)_{3-y}$, where $0 < y \leq 3$, M is a transition-metal atom, Y is Li or Na, and X = Si, As, or S and acts as a counter cation in the rhombohedral NASICON framework structure. In this aspect, the compound comprises a phosphate anion as at least part of an electrode material. In preferred embodiments, the compounds are used in the cathode of a rechargeable battery. Preferred compounds having this general formula include, but are not limited to $\text{Li}_{1+x}\text{Fe}_2(\text{SO}_4)_2(\text{PO}_4)$, where $0 \leq x \leq 1$.

The rhombohedral NASICON compounds described above may typically be prepared by preparing an aqueous solution comprising a lithium compound, an iron compound, a phosphate compound and a sulfate compound, evaporating the solution to obtain dry material and heating the dry material to about 500°C . Preferably, the aqueous starting solution comprises FeCl_3 , $(\text{NH}_4)_2\text{SO}_4$, and LiH_2PO_4 .

In a further embodiment, the invention provides electrode materials for a rechargeable electrochemical cell comprising an anode, a cathode and an electrolyte, with or without an electrode separator, where the electrode materials have a rhombohedral NASICON structure with the general formula $\text{A}_{3-x}\text{V}_2(\text{PO}_4)_3$. In these compounds, A may be Li, Na or a combination thereof and $0 \leq x \leq 2$. In preferred embodiments, the compounds are a single-phase rhombohedral NASICON material. Preferred formulas for

the rhombohedral NASICON electrode compounds having the general formula $A_{3-x}V_2(PO_4)_3$ include, but are not limited to those having the formula $Li_{2-x}NaV_2(PO_4)_3$, where $0 \leq x \leq 2$.

The rhombohedral NASICON materials of the general formula $A_{3-x}V_2(PO_4)_3$ may generally be prepared by the process outlined in FIG. 9. Alternatively, $Li_2NaV_2(PO_4)_3$ may be prepared by a direct solid-state reaction from $LiCO_3$, $NaCO_3$, $NH_4H_2PO_4 \cdot H_2O$ and V_2O_3 .

In a further aspect, the invention provides a secondary (rechargeable) battery where an electrochemical cell comprises two electrodes and an electrolyte, with or without an electrode separator. The electrodes are generally referred to as the anode and the cathode. The secondary batteries of the invention generally comprise as electrode material, and preferably as cathode material, the compounds described above. More particularly, the batteries of the invention have a cathode comprising the ordered olivine compounds described above or the rhombohedral NASICON compounds described above.

BRIEF DESCRIPTION OF THE DRAWINGS

The following drawings form part of the present specification and are included to demonstrate further certain aspects of the present invention. The invention may be better understood by reference to one or more of these drawings in combination with the detailed description of specific embodiments presented herein.

FIG. 1. FIG. 1 shows a typical polarization curve for the battery voltage V vs. the I delivered across a load. The voltage drop ($V_{oc} - V \equiv \eta(I)$) of a typical curve is a measure of the battery resistance $R_b(I)$. The interfacial voltage drops saturate in region (i). The slope of the curve in region (ii) is $dV/dI \approx R_{el} + R_c(A) + R_c(C)$, the sums of the electrolyte resistance R_{el} and the current-collector resistances at the anode and cathode. Region (iii) is diffusion-limited. At the higher currents I , normal processes do not bring ions to or remove them from the electrode/electrolyte interfaces rapidly enough to sustain an equilibrium reaction.

FIG. 2A, 2B and 2C. FIG. 2A shows discharge/charge curves at $0.05 \text{ mA} \cdot \text{cm}^{-2}$ ($0.95 \text{ mA} \cdot \text{g}^{-1}$) for the olivine $\text{Li}_{1-x}\text{FePO}_4$ as cathode and lithium as anode. A plateau at 3.4V corresponds to the $\text{Fe}^{3+}/\text{Fe}^{2+}$ redox couple relative to the lithium anode. A plateau at 4.1 V corresponds to the $\text{Mn}^{3+}/\text{Mn}^{2+}$ couple. FIG. 2B shows discharge/charge curves at $0.05 \text{ mA} \cdot \text{cm}^{-2}$ ($1.13 \text{ mA} \cdot \text{g}^{-1}$) for the olivine $\text{Li}_{1-x}\text{Fe}_{0.5}\text{Mn}_{0.5}\text{PO}_4$ as cathode relative to a lithium anode. FIG. 2C shows discharge/charge curves vs. lithium at $0.05 \text{ mA} \cdot \text{cm}^{-2}$ ($0.95 \text{ mA} \cdot \text{g}^{-1}$) for the olivine Li_xFePO_4 .

FIG. 3. FIG. 3 shows discharge/charge curves of an $\text{FePO}_4/\text{LiClO}_4 + \text{PC} + \text{DME}/\text{Li}$ coin cell at $185 \text{ mA} \cdot \text{g}^{-1}$ for FePO_4 prepared by chemical extraction of Li (delithiation) from LiFePO_4 .

FIG. 4. Schematic representation of the motion of $\text{LiFePO}_4/\text{FePO}_4$ interface on lithium insertion in to a particle of FePO_4 .

FIG. 5A and 5B. FIG. 5A shows the rhombohedral $R3c$ (NASICON) framework structure of $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$ prepared by ion exchange from $\text{Na}_3\text{Fe}_2(\text{PO}_4)_3$; FIG. 5B shows the monoclinic $P2_1/n$ framework structure of $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$ prepared by solid-state reaction.. The large, open three-dimensional framework of FeO_6 octahedra and PO_4 tetrahedra allows an easy diffusion of the lithium ions.

FIG. 6A and 6B. FIG. 6A shows discharge/charge curves vs. lithium at $0.1 \text{ mA} \cdot \text{cm}^{-2}$ for rhombohedral $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$ where $0 < x < 2$. The shape of the curve for lithium insertion into rhombohedral $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$ is surprisingly different from that for the monoclinic form. However, the average V_{oc} at 2.8 V remains the same. The Li^+ -ion distribution in the interstitial space appears to vary continuously with x with a high degree of disorder. FIG. 6B shows discharge/charge curves vs. lithium at $0.1 \text{ mA} \cdot \text{cm}^{-2}$ for monoclinic $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$ where $0 < x < 2$.

FIG. 7A and 7B. FIG. 7A shows discharge curves vs. a lithium anode at current densities of $0.05\text{-}0.5 \text{ mA} \cdot \text{cm}^{-2}$ for rhombohedral $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$. A reversible capacity loss on increasing the current density from 0.05 to $0.5 \text{ mA} \cdot \text{cm}^{-2}$ is shown. This loss is much reduced compared to what is encountered with the monoclinic system.

FIG. 7B shows discharge curves at current densities of $0.05\text{--}0.5\text{ mA} \cdot \text{cm}^{-2}$ for monoclinic $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$.

FIG. 8. FIG. 8 shows discharge/charge curves at $0.05\text{ mA} \cdot \text{cm}^{-2}$ ($0.95\text{ mA} \cdot \text{g}^{-1}$) for the rhombohedral $\text{Li}_x\text{NaV}_2(\text{PO}_4)_3$. Rhombohedral $\text{Li}_2\text{NaV}_2(\text{PO}_4)_3$ reversibly intercalates 1.5 Li per formula unit for a discharge capacity of $100\text{ mAh} \cdot \text{g}^{-1}$ with average closed-circuit voltage of 3.8 V vs. a lithium anode.

FIG. 9. FIG. 9 illustrates the solid-state synthesis of $\text{Li}_2\text{NaV}_2(\text{PO}_4)_3$ having the rhombohedral NASICON framework.

FIG. 10 FIG. 10 shows discharge/charge curves vs. lithium at $0.1\text{ mA} \cdot \text{cm}^{-2}$ for rhombohedral $\text{Li}_{1+x}\text{Fe}_2(\text{PO}_4)(\text{SO}_4)_2$ where $0 \leq x \leq 2$.

DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

Present-day secondary (rechargeable) lithium batteries use a solid reductant as the anode and a solid oxidant as the cathode. It is important that the chemical reactions at the anode and cathode of a lithium secondary battery be reversible. On discharge, the metallic anode supplies Li^+ ions to the Li^+ -ion electrolyte and electrons to the external circuit. The cathode is a host compound into/from which the working Li^+ ion of the electrolyte can be inserted/extracted reversibly as a guest species over a large solid-solubility range (Goodenough 1994). When the Li^+ ions are inserted as a guest species into the cathode, they are charge-compensated by electrons from the external circuit. On charge, the removal of electrons from the cathode by an external field releases Li^+ ions back to the electrolyte to restore the parent host structure. The resultant addition of electrons to the anode by the external field attracts charge-compensating Li^+ ions back into the anode to restore it to its original composition.

The present invention provides new materials for use as cathodes in lithium secondary (rechargeable) batteries. It will be understood that the anode for use with the cathode material of the invention may be any lithium anode material, such as a reductant host for lithium or elemental lithium itself. Preferably, the anode material will be a reductant host for lithium. Where both the anode and cathode are hosts for the reversible insertion or removal of the working ion into/from the electrolyte, the electrochemical cell

is commonly called a "rocking-chair" cell. An implicit additional requirement of a secondary battery is maintenance not only of the electrode/electrolyte interfaces, but also of electrical contact between host particles, throughout repeated discharge/recharge cycles.

5 Since the volumes of the electrode particles change as a result of the transfer of atoms from one to another electrode in a reaction, this requirement normally excludes the use of a crystalline or glassy electrolyte with a solid electrode. A non-aqueous liquid or polymer electrolyte having a large energy-gap window between its highest occupied molecular orbital (HOMO) and its lowest unoccupied molecular orbital (LUMO) is used
10 with secondary lithium batteries in order to realize higher voltages. For example, practical quantities of very ionic lithium salts such as LiClO_4 , LiBF_4 and LiPF_6 can be dissolved in empirically optimized mixtures of propylene carbonate (PC), ethylene carbonate (EC), or dimethyl carbonate (DMC) to provide acceptable electrolytes for use with the cathodes of the invention. It will be recognized by those of skill in the art that
15 the $(\text{ClO}_4)^-$ anion is explosive and not typically suitable for commercial applications.

General Design Considerations

The power output P of a battery is the product of the electric current I delivered by the battery and the voltage V across the negative and positive posts (equation 1).

$$P = IV$$

(1)

The voltage V is reduced from its open-circuit value V_{oc} ($I = 0$) by the voltage drop IR_b
25 due to the internal resistance R_b of the battery (equation 2).

$$V = V_{\text{oc}} - IR_b$$

(2)

The open-circuit value of the voltage is governed by equation 3.

$$V_{oc} = (\mu_A - \mu_C)/(-nF) < 5V$$

(3)

In equation 3, n is the number of electronic charges carried by the working ion and F is Faraday's constant. The magnitude of the open-circuit voltage is constrained to $V_{oc} < 5V$ not only by the attainable difference $\mu_A - \mu_C$ of the electrochemical potentials of the anode reductant and the cathode oxidant, but also by the energy gap E_g between the HOMO (highest occupied molecular orbital) and the LUMO (lowest unoccupied molecular orbital) of a liquid electrolyte or by the energy gap E_g between the top of the valence band and the bottom of the conduction band of a solid electrolyte.

The chemical potential μ_A , which is the Fermi energy ε_F of a metallic-reductant anode or the HOMO of a gaseous or liquid reductant, must lie below the LUMO of a liquid electrolyte or the conduction band of a solid electrolyte to achieve thermodynamic stability against reduction of the electrolyte by the reductant. Similarly, the chemical potential μ_C , which is the LUMO of a gaseous or liquid oxidant or the Fermi energy of a metallic-oxidant cathode, must lie above the HOMO of a liquid electrolyte or the valence band of a solid electrolyte to achieve thermodynamic stability against oxidation of the electrolyte by the oxidant. Thermodynamic stability thus introduces the constraint

$$\mu_A - \mu_C \leq E_g$$

(4)

as well as the need to match the "window" E_g of the electrolyte to the energies μ_A and μ_C of the reactants to maximize V_{oc} . It follows from equations 1 and 2 that realization of a high maximum power P_{max} (equation 5) requires, in addition to as high a V_{oc} as possible, a low internal battery resistance R_b (see equation 6).

-11-

$$P_{\max} = I_{\max} V_{\max}$$

(5)

$$R_b = R_{el} + R_{in}(A) + R_{in}(C) + R_c(A) + R_c(C)$$

5 (6)

The electrolyte resistance R_{el} to the ionic current is proportional to the ratio of the effective thickness L to the geometrical area A of the interelectrode space that is filled with an electrolyte of ionic conductivity σ_i (equation 7).

$$R_{el} = (L/\sigma_i A)$$

10 (7)

Since ions move diffusively, σ_i (see equation 8) increases with temperature. A
 15 $\sigma_i \leq 0.1 \text{ Scm}^{-1}$ (the maximum σ_i represents the room-temperature protonic conductivity σ_{H^+} in a strong acid) at an operating temperature T_{op} dictates the use of a membrane separator of large geometrical area A and small thickness L .

$$\sigma_{Li} = (B/T) \exp(-E_a/kT)$$

20 (8)

The resistance to transport of the working ion across the electrolyte-electrode interfaces is proportional to the ratio of the geometrical and interfacial areas at each electrode:

$$R_{in} \sim A/A_{in}$$

25 (9)

where the chemical reaction of the cell involves ionic transport across an interface,
 30 equation 9 dictates construction of a porous, small-particle electrode. Achievement and

retention of a high electrode capacity, *i.e.*, utilization of a high fraction of the electrode material in the reversible reaction, requires the achievement and retention of good electronic contact between particles as well as a large particle-electrolyte interface area over many discharge/charge cycles. If the reversible reaction involves a first-order phase change, the particles may fracture or lose contact with one another on cycling to break a continuous electronic pathway to the current collector.

Loss of interparticle electrical contact results in an irreversible loss of capacity. There may also be a reversible capacity fade. Where there is a two-phase process (or even a sharp guest-species gradient at a diffusion front) without fracture of the particles, the area of the interface (or diffusion front) decreases as the second phase penetrates the electrode particle. At a critical interface area, diffusion across the interface may not be fast enough to sustain the current I , so not all of the particle is accessible. The volume of inaccessible electrode increases with I , which leads to a diffusion-limited reversible capacity fade that increases with I . This problem becomes more important at lower ionic conductivity σ_{Li} .

The battery voltage V vs. the current I delivered across a load is called the polarization curve. The voltage drop ($V_{oc} - V$) $\equiv \eta(I)$ of a typical curve, FIG. 1, is a measure of the battery resistance (see equation 10).

$$R_b(I) = \eta(I)/I$$

(10)

On charging, $\eta(I) = (V_{app} - V_{oc})$ is referred to as an overvoltage. The interfacial voltage drops saturate in region (i) of FIG. 1; therefore in region (ii) the slope of the curve is

$$dV/dI \approx R_{el} + R_c(A) + R_c(C)$$

(11)

Region (iii) is diffusion-limited; at the higher currents I , normal processes do not bring ions to or remove them from the electrode/electrolyte interfaces rapidly enough to sustain an equilibrium reaction.

The battery voltage V vs. the state of charge, or the time during which a constant current I has been delivered, is called a discharge curve.

Cathode Materials

The cathode material of the present invention, for use in a secondary lithium battery, consists of a host structure into which lithium can be inserted reversibly. The maximum power output, P_{\max} (see equation 5), that can be achieved by a cell depends on the open-circuit voltage $V_{\text{oc}} = \Delta E/e$ and the overvoltage $\eta(I)$ at the current I_{\max} of maximum power

$$V_{\max} = V_{\text{oc}} - \eta(I_{\max})$$

(12)

ΔE is the energy difference between the work function of the anode (or the HOMO of the reductant) and that of the cathode (or the LUMO of the oxidant). In order to obtain a high V_{oc} , it is necessary to use a cathode that is an oxide or a halide. It is preferable that the cathode be an oxide in order to achieve a large V_{oc} and good electronic conductivity. To minimize $\eta(I_{\max})$, the electrodes must be good electronic as well as ionic conductors and they must offer a low resistance to mass transfer across the electrode/electrolyte interface. To obtain a high I_{\max} , it is necessary to have a large electrode/electrolyte surface area. In addition, where there is a two-phase interface within the electrode particle, the rate of mass transfer across this interface must remain large enough to sustain the current. This constraint tends to limit the electrode capacity more as the current increases.

Oxide host structures with close-packed oxygen arrays may be layered, as in $\text{Li}_{1-x}\text{CoO}_2$ (Mizushima, *et al.* 1980), or strongly bonded in three dimensions (3D) as in the manganese spinels $\text{Li}_{1-x}[\text{Mn}_2]\text{O}_4$ (Thackeray 1995; Thackeray *et al.* 1983;

Thackeray *et al.* 1984; Guyomard and Tarascon 1992; and Masquelier *et al.* 1996). Li intercalation into a van der Waals gap between strongly bonded layers may be fast, but it can also be accompanied by unwanted species from a liquid electrolyte. On the other hand, strong 3D bonding within a close-packed oxygen array, as occurs in the spinel framework $[\text{Mn}_2]\text{O}_4$, offers too small a free volume for the guest Li^+ ions to have a high mobility at room temperature, which limits I_{max} . Although this constraint in volume of the interstitial space makes the spinel structure selective for insertion of Li^+ ions, it reduces the Li^+ -ion mobility and hence Li^+ -ion conductivity σ_{Li} . The oxospinelns have a sufficiently high σ_{Li} to be used commercially in low-power cells (Thackeray *et al.*, 1983) but would not be acceptable for the high power cells of the insertion.

The present invention overcomes these drawbacks by providing cathode materials containing larger tetrahedral polyanions which form 3D framework host structures with octahedral-site transition-metal oxidant cations. In the cathode materials of the invention having the NASICON structure, the transition-metal ions are separated by the polyanions, so the electronic conductivity is polaronic rather than metallic. Nevertheless, the gain in σ_{Li} more than offsets the loss in electronic conductivity.

Variation of the energy of a given cation redox couple from one compound to another depends on two factors: (a) the magnitude of the crystalline electric field at the cation, which may be calculated for a purely ionic model by a Madelung summation of the Coulomb fields from the other ions present, and (b) the covalent contribution to the bonding, which may be modulated by the strength of the covalent bonding at a nearest-neighbor counter cation. The stronger is the negative Madelung potential at a cation, the higher is a given redox energy of a cation. Similarly the stronger is the covalent bonding of the electrons at a transition-metal cation, the higher is a given redox energy of that cation. The lower the redox energy of the cation host transition-metal ion, the larger is V_{oc} .

The redox couples of interest for a cathode are associated with antibonding states of d-orbital parentage at transition-metal cations M or 4f-orbital parentage at rare-earth cations Ln in an oxide. The stronger is the cation-anion covalent mixing, the higher is the energy of a given LUMO/HOMO redox couple. Modulation of the strength of the

cation-anion covalence at a given M or Ln cation by nearest-neighbor cations that compete for the same anion valence electrons is known as the inductive effect. Changes of structure alter primarily the Madelung energy as is illustrated by raising of the redox energy within a spinel $[M_2]O_4$ framework by about 1 eV on transfer of Li^+ ions from tetrahedral to octahedral interstitial sites. Changing the counter cation, but not the structure, alters primarily the inductive effect, as is illustrated by a lowering of the Fe^{3+}/Fe^{2+} redox energy by 0.6 eV on changing $(MoO_4)^{2-}$ or $(WO_4)^{2-}$ to $(SO_4)^{2-}$ polyanions in isostructural $Fe_2(XO_4)_3$ compounds. Raising the energy of a given redox couple in a cathode lowers the voltage obtained from cells utilizing a common anode. Conversely, raising the redox energy of an anode raises the cell voltage with respect to a common cathode.

The invention provides new cathode materials containing oxide polyanions, including the oxide polyanion $(PO_4)^{3-}$ as at least one constituent, for use in secondary (rechargeable) batteries. For example, the cathode materials of the present invention may have the general formula $LiM(PO_4)$ with the ordered olivine structure or the more open rhombohedral NASICON framework structure. The cathode materials of the present invention have the general formula $LiM(PO_4)$ for the ordered olivine structure, or $Y_xM_2(PO_4)_y(XO_4)_{3-y}$, where $0 < y \leq 3$, M is a transition-metal atom, Y is Li or Na and X = Si, As or S and acts as a counter cation, for the rhombohedral NASICON framework structure.

The olivine structure of Mg_2SiO_4 consists of a slightly distorted array of oxygen atoms with Mg^{2+} ions occupying half the octahedral sites in two different ways. In alternate basal planes, they form zigzag chains of corner-shared octahedra running along the *c*-axis and in the other basal planes they form linear chains of edge-shared octahedra running also along the *c*-axis.

In the ordered $LiMPO_4$ olivine structures of the invention, the M atoms occupy the zigzag chains of octahedra and the Li atoms occupy the linear chains of the alternate planes of octahedral sites. In this embodiment of the present invention, M is preferably Mn, Fe, Co, Ni or combinations thereof. Removal of all of the lithium atoms leaves the layered $FePO_4$ -type structure, which has the same *Pbnm* orthorhombic space group.

These phases may be prepared from either end, *e.g.*, LiFePO_4 (triphylite) or FePO_4 (heterosite), by reversible extraction or insertion of lithium.

FIG. 2A, FIG. 2B and FIG. 2C show discharge/charge curves *vs.* lithium at $0.05 \text{ mA} \times \text{cm}^{-2}$ ($0.95 \text{ mA} \times \text{g}^{-1}$ and $1.13 \text{ mA} \times \text{g}^{-1}$, respectively) for $\text{Li}_{1-x}\text{FePO}_4$, $\text{Li}_{1-x}\text{Fe}_{0.5}\text{Mn}_{0.5}\text{PO}_4$ and Li_xFePO_4 , respectively, where $0 \leq x \leq 5$. A plateau at 3.4 V corresponds to the $\text{Fe}^{3+}/\text{Fe}^{2+}$ redox couple and a plateau at 4.1 V corresponds to the $\text{Mn}^{3+}/\text{Mn}^{2+}$ couple. With LiClO_4 in PC and DME as the electrolyte, it is only possible to charge up a cathode to 4.3 V *vs.* a lithium anode, so it was not possible to extract lithium from LiMnPO_4 , LiCoPO_4 and LiNiPO_4 with this electrolyte. However, in the presence of iron, the $\text{Mn}^{3+}/\text{Mn}^{2+}$ couple becomes accessible. The inaccessibility is due to the stability of the $\text{Mn}^{3+}/\text{Mn}^{2+}$, $\text{Co}^{3+}/\text{Co}^{2+}$ and $\text{Ni}^{3+}/\text{Ni}^{2+}$ couples in the presence of the polyanion $(\text{PO}_4)^{3-}$. The relatively strong covalence of the PO_4 tetrahedron of the compounds of the present invention stabilizes the redox couples at the octahedral sites to give the high V_{oc} 's that are observed.

Insertion of lithium into FePO_4 was reversible over the several cycles studied. FIG. 3 shows discharge/charge curves of $\text{FePO}_4/\text{LiClO}_4 + \text{PC} + \text{DME}/\text{Li}$ coin cell at $185 \text{ mA} \cdot \text{g}^{-1}$ for FePO_4 prepared by chemical extraction of Li (delithiation) from LiFePO_4 . The Li_xFePO_4 material of the present invention represents a cathode of good capacity and contains inexpensive, environmentally benign elements. While a nearly close-packed-hexagonal oxide-ion array apparently provides a relatively small free volume for Li^+ -ion motion, which would seem to support only relatively small current densities at room temperature, increasing the current density does not lower the closed-circuit voltage V . Rather, it decreases, reversibly, the cell capacity. Capacity is easily restored by reducing the current.

As illustrated schematically in FIG. 4, lithium insertion proceeds from the surface of the particle moving inwards behind a two-phase interface. In the system shown, it is a $\text{Li}_x\text{FePO}_4/\text{Li}_{1-x}\text{FePO}_4$ interface. As the lithiation proceeds, the surface area of the interface shrinks. For a constant rate of lithium transport per unit area across the interface, a critical surface area is reached where the rate of total lithium transported across the interface is no longer able to sustain the current. At this point, cell

performance becomes diffusion-limited. The higher the current, the greater is the total critical interface area and, hence, the smaller the concentration x of inserted lithium before the cell performance becomes diffusion-limited. On extraction of lithium, the parent phase at the core of the particle grows back towards the particle surface. Thus, the parent phase is retained on repeated cycling and the loss in capacity is reversible on lowering the current density delivered by the cell. Therefore, this loss of capacity does not appear to be due to a breaking of the electrical contact between particles as a result of volume changes, a process that is normally irreversible.

The invention further provides new cathode materials exhibiting a rhombohedral NASICON framework. NASICON, as used herein, is an acronym for the framework host of a sodium superionic conductor $\text{Na}_{1+3x}\text{Zr}_2(\text{P}_{1-x}\text{Si}_x\text{O}_4)_3$. The compound $\text{Fe}_2(\text{SO}_4)_3$ has two forms, a rhombohedral NASICON structure and a related monoclinic form (Goodenough *et al.* 1976; Long *et al.* 1979). Each structure contains units of two FeO_6 octahedra bridged by three corner-sharing SO_4 tetrahedra. These units form 3D frameworks by the bridging SO_4 tetrahedra of one unit sharing corners with FeO_6 octahedra of neighboring $\text{Fe}_2(\text{SO}_4)_3$ elementary building blocks so that each tetrahedron shares corners with only octahedra and each octahedron with only tetrahedra. In the rhombohedral form, the building blocks are aligned parallel; while they are aligned nearly perpendicular to one another in the monoclinic phase. The collapsed monoclinic form has a smaller free volume for Li^+ -ion motion which is why the rhombohedral form is preferred. In these structures, the FeO_6 octahedra do not make direct contact, so electron transfer from an Fe^{2+} to an Fe^{3+} ion is polaronic and therefore activated.

$\text{Li}_x\text{Fe}_2(\text{SO}_4)_3$ has been reported to be a candidate material for the cathode of a Li^+ -ion rechargeable battery with a $V_{\text{oc}} = 3.6$ V vs. a lithium anode (Manthiram and Goodenough 1989). While the sulfates would seem to provide the desired larger free volume for Li, batteries using sulfates in the cathode material tend to exhibit phase-transition problems, lowering the electronic conductivity. The reversible lithium insertion into both rhombohedral and monoclinic $\text{Fe}_2(\text{SO}_4)_3$ gives a flat closed-circuit voltage vs. a lithium anode of 3.6 V (Manthiram and Goodenough 1989; Okada *et al.* 1994; Nanjundaswamy *et al.* 1996). Neither parent phase has any significant solid

5 solution with the orthorhombic lithiated phase $\text{Li}_2\text{Fe}_2(\text{SO}_4)_3$, which is derived from the rhombohedral form of $\text{Fe}_2(\text{SO}_4)_3$ by a displacive transition that leaves the framework intact. Powder X-ray diffraction verifies that lithiation occurs via a two-phase process (Nanjundaswamy *et al.* 1996). Increasing the current density does not change significantly the closed-circuit voltage V , but it does reduce reversibly the capacity. The
10 reduction in capacity for a given current density is greater for the motion of the lithiated interface. The interstitial space of the framework allows fast Li^+ -ion motion, but the movement of lithium across the orthorhombic/monoclinic interface is slower than that across the orthorhombic/rhombohedral interface, which makes the reversible loss of capacity with increasing current density greater for the monoclinic than for the
15 rhombohedral parent phase.

The cathode materials of the invention avoid the phase transition of known sulfate cathode materials by incorporating one or more phosphate ions as at least one of the constituents of the cathode material. The rhombohedral $R3c$ (NASICON) and monoclinic $P2_1/n$ framework structures of $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$ are similar to those for the
20 sulfates described above, as illustrated in FIG. 5A and FIG. 5B.

A further embodiment of the invention is a rhombohedral NASICON cathode material having the formula $\text{A}_{3-x}\text{V}_2(\text{PO}_4)_3$, where A may be Li, Na or a combination thereof. Rhombohedral $\text{A}_{3-x}\text{V}_2(\text{PO}_4)_3$ reversibly intercalates 1.5 Li per formula unit for a discharge capacity of $100 \text{ mAh} \cdot \text{g}^{-1}$ with average closed-circuit voltage being 3.8 V vs. a
25 lithium anode (see FIG. 8). The voltage and capacity performances of the rhombohedral $\text{A}_{3-x}\text{V}_2(\text{PO}_4)_3$ compounds of the invention are comparable to the high-voltage cathode materials LiMn_2O_4 (4.0 V), LiCoO_2 (4.0 V) and LiNiO_2 (4.0 V). The large, open three-dimensional framework of VO_6 octahedra and PO_4 tetrahedra allows an easy diffusion of the lithium ions, making it attractive for high-power batteries. A further advantage of
30 this material is that it includes a cheaper and less toxic transition-metal element (V) than the already developed systems using Co, Ni, or Mn.

EXAMPLES

Example 1. Ordered Olivine LiMPO_4 Compounds

The ordered-olivine compound LiFePO_4 was prepared from intimate mixtures of stoichiometric proportions of Li_2CO_3 or $\text{LiOH}\cdot\text{H}_2\text{O}$, $\text{Fe}\{\text{CH}_2\text{COOH}\}_2$ and $\text{NH}_4\text{H}_2\text{PO}_4\cdot\text{H}_2\text{O}$; the mixtures were calcined at 300-350°C to eliminate NH_3 , H_2O , and CO_2 and then heated in Ar at about 800°C for 24 hours to obtain LiFePO_4 . Similar solid-state reactions were used to prepare LiMnPO_4 , $\text{LiFe}_{1-x}\text{Mn}_x\text{PO}_4$, LiCoPO_4 and LiNiPO_4 . FePO_4 was obtained from LiFePO_4 by chemical extraction of Li from LiFePO_4 . Charge/discharge curves for $\text{Li}_{1-x}\text{FePO}_4$ and discharge/charge cycles for Li_xFePO_4 gave similar results with a voltage of almost 3.5 V vs. lithium for a capacity of 0.6 Li/formula unit at a current density of $0.05 \text{ mA}\cdot\text{cm}^{-2}$ (See FIG. 2A and FIG. 2C). The electrolyte used had a window restricting voltages to $V < 4.3 \text{ V}$. Li extraction was not possible from LiMnPO_4 , LiCoPO_4 , and LiNiPO_4 with the electrolyte used because these require a voltage $V > 4.3 \text{ V}$ to initiate extraction. However, Li extraction from $\text{LiFe}_{1-x}\text{Mn}_x\text{PO}_4$ was performed with $0 \leq x \leq 0.5$, and the $\text{Mn}^{3+}/\text{Mn}^{2+}$ couple give a voltage plateau at 4.0 V vs. lithium.

Example 2 Rhombohedral NASICON $\text{Li}_x\text{M}_2(\text{PO}_4)_3$ Structures

The inventors compared redox energies in isostructural sulfates with phosphates to obtain the magnitude of the change due to the different inductive effects of sulfur and phosphorus. Rhombohedral $\text{Li}_{1+x}\text{Ti}_2(\text{PO}_4)_3$ has been shown to exhibit a flat open-circuit voltage $V_{\text{oc}} = 2.5 \text{ V}$ vs. lithium, which is roughly 0.8 V below the $\text{Ti}^{4+}/\text{Ti}^{3+}$ level found for $\text{FeTi}(\text{SO}_4)_3$. The flat voltage $V(x)$ is indicative of a two-phase process. A coexistence of rhombohedral and orthorhombic phases was found for $x = 0.5$ (Delmas and Nadiri 1988; Wang and Hwu 1992). $\text{Li}_{2+x}\text{FeTi}(\text{PO}_4)_3$ of the present invention remains single phase on discharge.

All three phosphates $\text{Li}_3\text{M}_2(\text{PO}_4)_3$, where $\text{M} = \text{Fe}$, Fe/V , or V , have the monoclinic $\text{Fe}_2(\text{SO}_4)_3$ structure if prepared by solid-state reaction. The inventors have found that these compounds exhibit a rhombohedral structure when prepared by ion exchange in LiNO_3 at 300°C from the sodium analog $\text{Na}_3\text{Fe}_2(\text{PO}_4)_3$. The discharge/charge curve of FIG. 6A for lithium insertion into rhombohedral

Li_{3+x}Fe₂(PO₄)₃ exhibits an average V_{oc} of 2.8 V. This is surprisingly different from the curves for the monoclinic form (See FIG. 6B). The inventors have found that up to two lithiums per formula unit can be inserted into Li₃Fe₂(PO₄)₃, leading to Li₅Fe₂(PO₄)₃. The Li⁺-ion distribution in the interstitial space of Li_{3+x}Fe₂(PO₄)₃, where $0 < x < 2$, appears to vary continuously with x with a high degree of disorder. FIG. 7A shows a reversible capacity loss on increasing the current density from 0.05 to 0.5 mA · cm⁻². A reversible discharge capacity of 95 mAh · g⁻¹ is still observed for rhombohedral Li_{3+x}Fe₂(PO₄)₃ at a current density of 20 mA · g⁻¹. This is much reduced compared to what is encountered with the monoclinic system (See FIG. 7B). With a current density of 23 mA · g⁻¹ (or 1 mA · cm⁻²), the initial capacity of 95 mAh · g⁻¹ was maintained in a coin cell up to the 40th cycle.

Another cathode material of the present invention, Li₂FeTi(PO₄)₃, having the NASICON framework was prepared by solid-state reaction. This material has a voltage ranging from 3.0 to 2.5 V.

Rhombohedral TiNb(PO₄)₃ can be prepared by solid-state reaction at about 1200°C. Up to three Li atoms per formula unit can be inserted, which allows access to the Nb⁴⁺/Nb³⁺ couple at 1.8 V vs. lithium for $x > 2$ in Li_xTiNb(PO₄)₃. Two steps are perhaps discernible in the compositional range $0 < x < 2$; one in the range of $0 < x < 1$ corresponds to the Ti⁴⁺/Ti³⁺ couple in the voltage range 2.5 V < V < 2.7 V and the other for $1 < x < 2$ to the Nb³⁺/Nb⁴⁺ couple in the range 2.2 V < V < 2.5 V. It appears that these redox energies overlap. This assignment is based on the fact that the Ti⁴⁺/Ti³⁺ couple in Li_{1-x}Ti₂(PO₄)₃ gives a flat plateau at 2.5 V due to the presence of two phases, rhombohedral LiTi₂(PO₄)₃ and orthorhombic Li₃Ti₂(PO₄)₃. The presence of Nb in the structure suppresses the formation of the second phase in the range $0 < x < 2$.

Rhombohedral LiFeNb(PO₄)₃ and Li₂FeTi(PO₄)₃ can be prepared by ion exchange with molten LiNO₃ at about 300°C from NaFeNb(PO₄)₃ and Na₂FeTi(PO₄)₃, respectively. Two Li atoms per formula unit can be inserted reversibly into Li_{2+x}FeTi(PO₄)₃ with a little loss of capacity at 0.5 mA · cm⁻². Insertion of the first Li atom in the range 2.7 V < V < 3.0 V corresponds to the Fe³⁺/Fe²⁺ redox couple and of the second Li atom in the range of 2.5 V < V < 2.7 V to an overlapping Ti⁴⁺/Ti³⁺ redox couple.

5 The insertion of lithium into $\text{Li}_{1+x}\text{FeNb}(\text{PO}_4)_3$ gives a V vs. x curve that further verifies the location of the relative positions of the $\text{Fe}^{3+}/\text{Fe}^{2+}$, $\text{Nb}^{5+}/\text{Nb}^{4+}$ redox energies in phosphates with NASICON-related structures. It is possible to insert three lithium atoms into the structure; and there are three distinct plateaus corresponding to $\text{Fe}^{3+}/\text{Fe}^{2+}$ at 2.8 V, $\text{Nb}^{5+}/\text{Nb}^{4+}$ at 2.2 V, and $\text{Nb}^{4+}/\text{Nb}^{5+}$ at 1.7 V vs. lithium in the discharge curve.

10 The rhombohedral $\text{A}_{3-x}\text{V}_2(\text{PO}_4)_3$ compounds of the invention can be prepared by ionic exchange from the monoclinic sodium analog $\text{Na}_3\text{V}_2(\text{PO}_4)_3$. The inventors were also able to prepare the rhombohedral $\text{Li}_2\text{NaV}_2(\text{PO}_4)_3$ with the NASICON framework by a direct solid-state reaction (FIG. 9). The discharge/charge curves at $0.05 \text{ mA} \cdot \text{cm}^{-2}$ ($0.95 \text{ mA} \cdot \text{g}^{-1}$) for the rhombohedral $\text{Li}_x\text{NaV}_2(\text{PO}_4)_3$ are shown in FIG. 8.

15 The rhombohedral $\text{LiFe}_2(\text{SO}_4)_2(\text{PO}_4)$ may be prepared by obtaining an aqueous solution comprising FeCl_3 , $(\text{NH}_4)_2\text{SO}_4$, and LiH_2PO_4 , stirring the solution and evaporating it to dryness, and heating the resulting dry material to about 500°C . Discharge/charge curves vs. lithium at $0.1 \text{ mA} \cdot \text{cm}^{-2}$ for rhombohedral $\text{Li}_{1+x}\text{Fe}_2(\text{PO}_4)(\text{SO}_4)_2$, where $0 < x < 3$, are shown in FIG. 10.

20 All of the compositions and/or methods disclosed and claimed herein can be made and executed without undue experimentation in light of the present disclosure. While the compositions and methods of this invention have been described in terms of preferred embodiments, it will be apparent to those of skill in the art that variations may be applied to the compositions and/or methods and in the steps or in the sequence of
25 steps of the method described herein without departing from the concept, spirit and scope of the invention. More specifically, it will be apparent that certain agents which are both chemically and structurally related may be substituted for the agents described herein to achieve similar results. All such substitutions and modifications apparent to those skilled in the art are deemed to be within the spirit, scope and concept of the invention as
30 defined by the appended claims.

REFERENCES

The following references, to the extent that they provide exemplary procedural or other details supplementary to those set forth herein, are specifically incorporated herein by reference.

Delmas, C., and A. Nadiri, *Mater. Res. Bull.*, 23, 63 (1988).

Goodenough, J. B., H.Y.P. Hong and J.A. Kafalas, *Mater. Res. Bull.* 11, 203, (1976).

Guyomard, D. and J. M. Tarascon, *J. Electrochem. Soc.*, 139, 937 (1992).

Long, G. J., G. Longworth, P. Battle, A.K. Cheetham, R.V. Thundathil and D. Beveridge, *Inorg. Chem.*, 18, 624 (1979).

Manthiram, A., and J. B. Goodenough, *J. Power Sources*, 26, 403 (1989).

Masquelier, C., M. Tabuchi, K. Ado, R. Kanno, Y. Kobayashi, Y. Maki, O. Nakamura and J. B. Goodenough, *J. Solid State Chem.*, 123, 255 (1996).

Mizushima, K., P.C. Jones, P.J. Wiseman and J. B. Goodenough, *Mater. Res. Bull.*, 15, 783 (1980).

Nanjundaswamy, K. S., *et al.*, "Synthesis, redox potential evaluation and electrochemical characteristics of NASICON-related 3D framework compounds," *Solid State Ionics*, 92 (1996) 1-10.

Nishi, Y., H. Azuma and A. Omaru, U.S. Patent No. 4,959,281, September 25, 1990.

Okada, S., K.S. Nanjundaswamy, A. Manthiram and J. B. Goodenough, *Proc. 36th Power Sources Conf.*, Cherry Hill at New Jersey (June 6-9, 1994).

Schöllhorn, R. and A. Payer, *Angew. Chem. (Int. Ed. Engl.)*, 24, 67 (1985).

Sinha, S. and D.W. Murphy, *Solid State Ionics*, 20, 81 (1986).

Thackeray, M. M. W.I.F. David, J. B. Goodenough and P. Groves, *Mater. Res. Bull.*, 20, 1137 (1983).

Thackeray, M. M., P.J. Johnson, L.A. de Picciotto, P.G. Bruce and J. B. Goodenough, *Mater. Res. Bull.*, 19, 179 (1984).

Thackeray, M. M., W.I.F. David, P.G. Bruce and J. B. Goodenough, *Mater. Res. Bull.* 18, 461 (1983).

Wang, S., and S. J. Hwu, *Chem. of Mater.* 4, 589 (1992).

CLAIMS

1. A cathode material for a rechargeable electrochemical cell, said cell also comprising an anode and an electrolyte, the cathode comprising a compound having the formula LiMPO_4 , where M is at least one first-row transition-metal cation.

2. The cathode material of claim 1, where M is further defined as being selected from the group consisting of Mn, Fe, Co, and Ni

3. The cathode material of claim 1, where M is further defined as being a combination of cations, at least one of which is selected from the group consisting of Mn, Fe, Co and Ni.

4. The cathode material of claim 3, where M is $\text{Fe}_{1-x}\text{Mn}_x$ or $\text{Fe}_{1-x}\text{Ti}_x$ and $0 < x < 1$.

5. The cathode material of claim 2, wherein the cathode material has the formula LiFePO_4 .

6. A cathode material for a rechargeable electrochemical cell, said cell also comprising an anode and an electrolyte, the cathode material comprising a rhombohedral NASICON material having the formula $\text{Y}_x\text{M}_2(\text{PO}_4)_3$, where M is at least one first-row transition-metal cation and $0 \leq x \leq 5$ and Y is Li or Na.

5 7. The cathode material of claim 5, where M is selected from the group consisting of Fe, V, Mn, and Ti.

8. The cathode material of claim 7, wherein the cathode material has the formula $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$, where $0 \leq x \leq 2$.

10 9. The cathode material of claim 7, wherein the cathode material has the formula $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$.

15 10. The cathode material of claim 7, having the formula $\text{Li}_{1+x}\text{Ti}_2(\text{PO}_4)_3$.

20 11. The cathode material of claim 7, having the formula $\text{Li}_2\text{FeTi}(\text{PO}_4)_3$.

12. The cathode material of claim 7, having the formula $\text{Li}_x\text{TiNb}(\text{PO}_4)_3$, where $0 \leq x \leq 2$.

25 13. The cathode material of claim 7, having the formula $\text{Li}_{1+x}\text{FeNb}(\text{PO}_4)_3$, where $0 \leq x \leq 2$.

14. The cathode material of claim 7, prepared by the process comprising the steps:

- 30 (a) preparing $\text{Na}_2\text{Fe}_2(\text{PO}_4)_3$; and
(b) contacting said $\text{Na}_2\text{Fe}_2(\text{PO}_4)_3$ with a molten lithium salt, such that an ionic exchange reaction occurs.

5 15. The cathode material of claim 7, prepared by a direct solid state reaction.

16. A cathode material for a rechargeable electrochemical cell, said cell also comprising an anode and an electrolyte, the cathode material comprising a rhombohedral NASICON
10 material having the formula $Y_xM_2(PO_4)_y(XO_4)_{3-y}$, where $0 < y \leq 3$, M is a transition-metal atom, $0 \leq x \leq 5$, Y is Li or Na, and X = Si, As, or S.

17. The cathode material of claim 16, wherein the cathode material has the formula
15 $Li_{1+x}Fe_2(SO_4)_2(PO_4)$, where $0 \leq x \leq 2$.

18. The cathode material of claim 17, prepared by the process comprising the steps:

- 20 (a) preparing an aqueous solution comprising $FeCl_3$, $(NH_4)_2SO_4$, and LiH_2PO_4 ;
(b) evaporating the solution to obtain dry material; and
(c) heating the dry material to about 500°C.

25 19. A cathode material for a rechargeable electrochemical cell also comprising an anode and an electrolyte, the cathode comprising a rhombohedral NASICON material having the formula $A_{3-x}V_2(PO_4)_3$, where A may be Li, Na or a combination thereof and $0 \leq x \leq 2$.

30 20. The cathode material of claim 19, wherein the cathode material has the formula $Li_{2-x}NaV_2(PO_4)_3$, where $0 \leq x \leq 2$.

-26-

5 21. The cathode material of claim 19, prepared by the process comprising the steps:

- (a) preparing $\text{Na}_3\text{V}_2(\text{PO}_4)_3$; and
- (b) contacting said $\text{Na}_3\text{V}_2(\text{PO}_4)_3$ with a molten lithium salt, such that an ionic exchange reaction occurs.

10 22. The cathode material of claim 19, prepared by a direct solid-state reaction.

15 23. A secondary battery comprising an anode, a cathode and an electrolyte, said cathode comprising an ordered olivine compound having the formula LiMPO_4 , where M is at least one first-row transition-metal cation.

20 24. The battery of claim 23, where M is further defined as being selected from the group consisting of Mn, Fe, Co, and Ni.

25 25. The battery of claim 23, where M is further defined as being a combination of cations, at least one of said cations being selected from the group consisting of Mn, Fe, Co, and Ni.

26. The battery of claim 25, wherein M is $\text{Fe}_{1-x}\text{Mn}_x$ or $\text{Fe}_{1-x}\text{Ti}_x$, where $0 \leq x \leq 1$.

30 27. A secondary battery comprising an anode, a cathode and an electrolyte, said cathode comprising a rhombohedral NASICON material having the formula $\text{Y}_x\text{M}_2(\text{PO}_4)_3$, where M is at least one first-row transition-metal cation and $0 \leq x \leq 5$ and Y is Li or Na, other than $\text{Li}_{2+x}\text{FeTi}(\text{PO}_4)_3$.

5 28. The battery of claim 27, where M is selected from the group consisting of Fe, V, Mn, and Ti.

10 29. The battery of claim 28, wherein the cathode material has the formula $\text{Li}_{3+x}\text{Fe}_2(\text{PO}_4)_3$, where $0 \leq x \leq 2$.

15 30. The battery of claim 29, wherein the cathode material has the formula $\text{Li}_3\text{Fe}_2(\text{PO}_4)_3$.

31. The battery of claim 28, wherein the cathode material has the formula $\text{Li}_2\text{FeTi}(\text{PO}_4)_3$.

20 32. The battery of claim 28, wherein the cathode material has the formula $\text{Li}_x\text{TiNb}(\text{PO}_4)_3$, where $0 \leq x \leq 2$.

25 33. The battery of claim 28, wherein the cathode material has the formula $\text{Li}_{1+x}\text{FeNb}(\text{PO}_4)_3$, $0 \leq x \leq 2$.

30 34. A secondary battery comprising an anode, a cathode and an electrolyte, said cathode comprising a rhombohedral NASICON material having the formula $\text{Y}_x\text{M}_2(\text{PO}_4)_y(\text{XO}_4)_{3-y}$, where $0 < y \leq 3$, M is a transition-metal atom, $0 \leq x \leq 5$, Y is Li or Na, and X = Si, As, or S.

-28-

5 35. The battery of claim 34, wherein said cathode material has the formula $\text{Li}_{1+x}\text{Fe}_2(\text{PO}_4)(\text{SO}_4)_2$, where $0 \leq x \leq 2$.

10 36. A secondary battery comprising an anode, a cathode and an electrolyte, said cathode comprising a rhombohedral NASICON material having the formula $\text{A}_{3-x}\text{V}_2(\text{PO}_4)_3$, where A may be Li, Na or a combination thereof and $0 \leq x \leq 2$.

15 37. The battery of claim 36, wherein the cathode material has the formula $\text{Li}_{2+x}\text{NaV}_2(\text{PO}_4)_3$, where $0 \leq x \leq 2$.

1/15

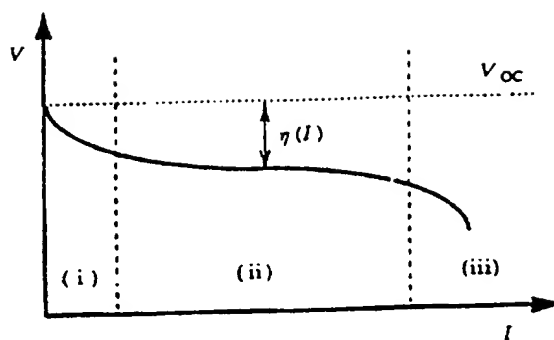


FIG. 1

2/15

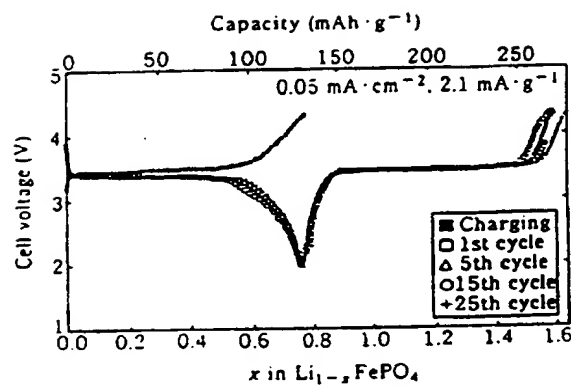


FIG. 2A

3/15

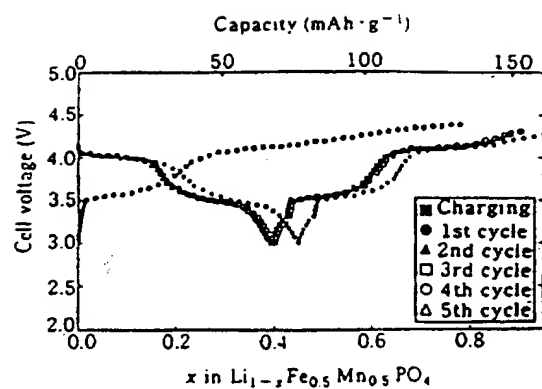


FIG. 2B

4/15

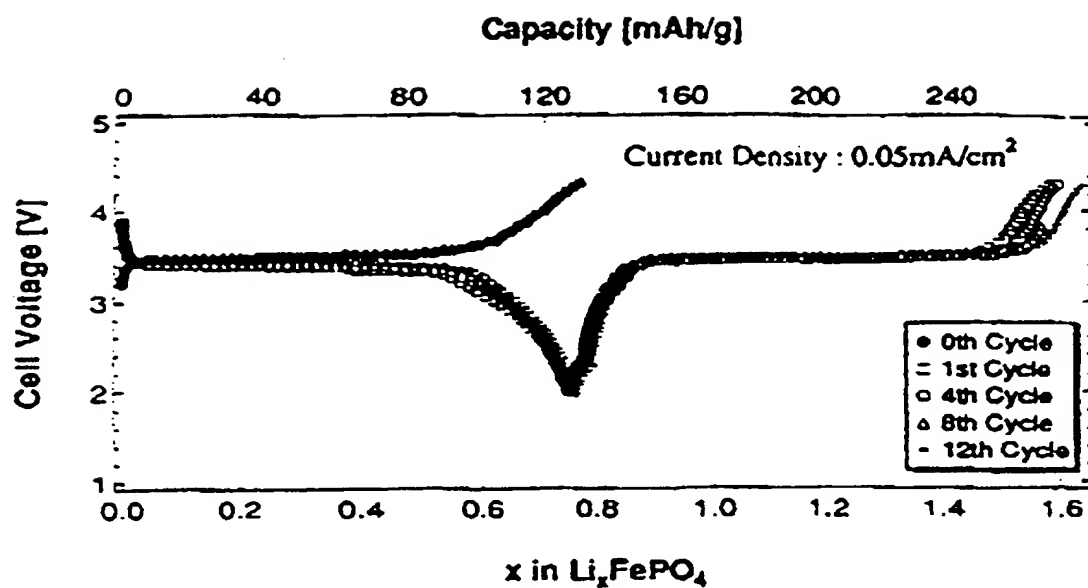


FIG. 2C

5/15

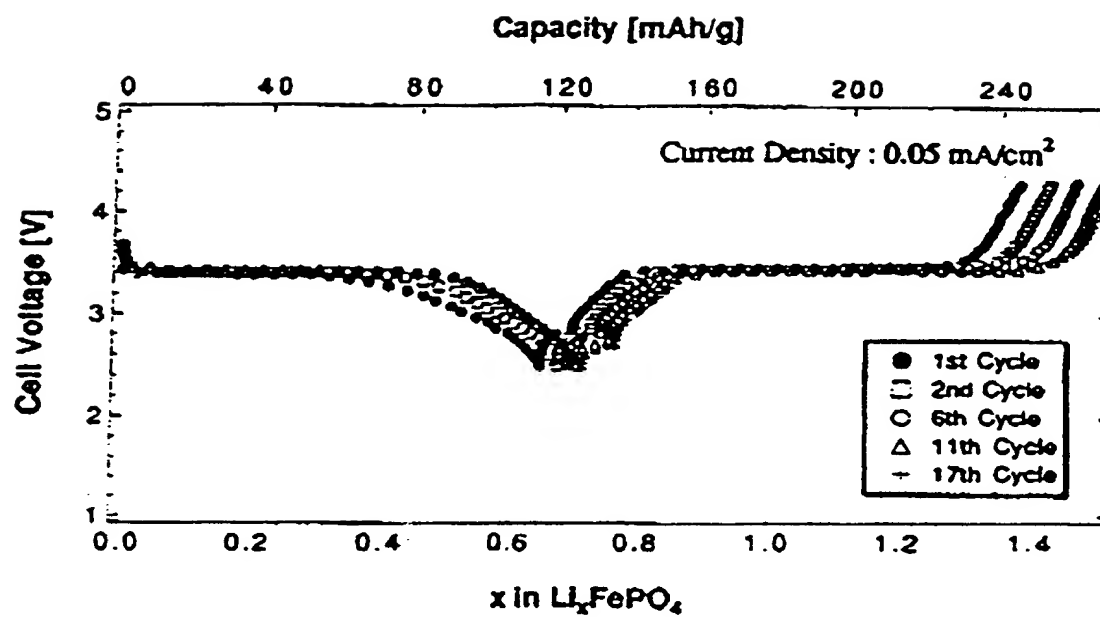


FIG. 3

6/15

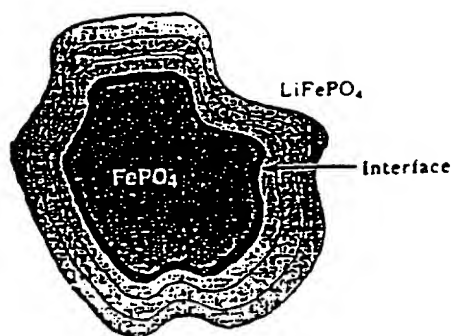


FIG. 4

7/15

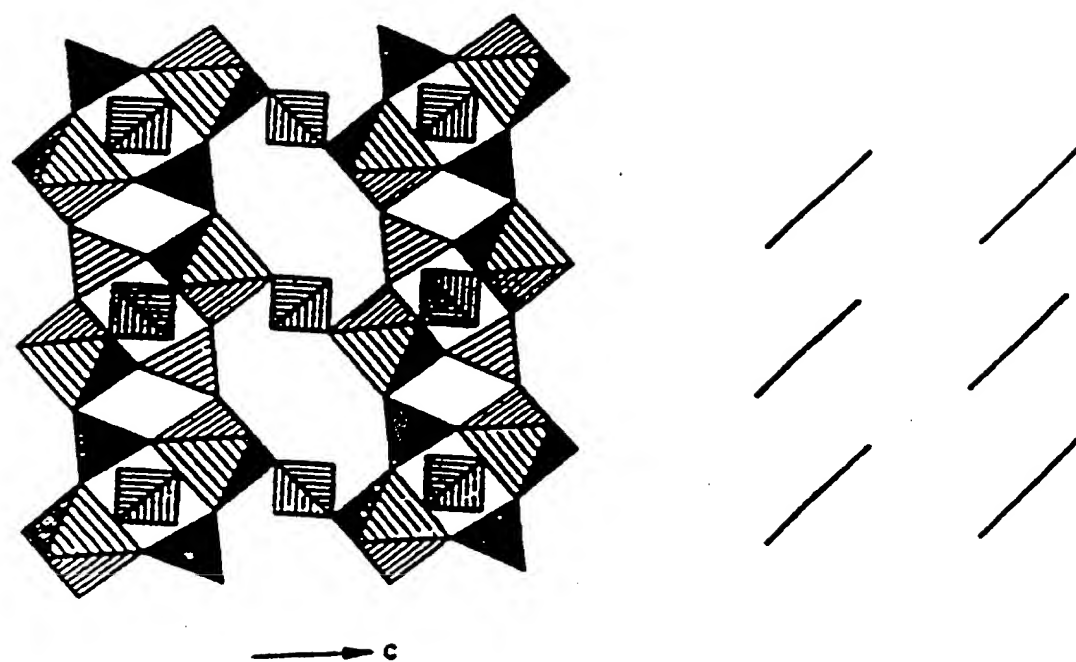


FIG. 5A

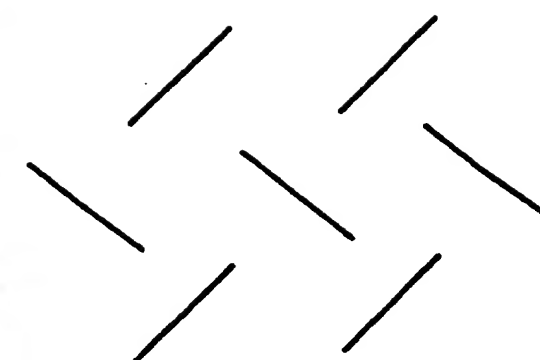
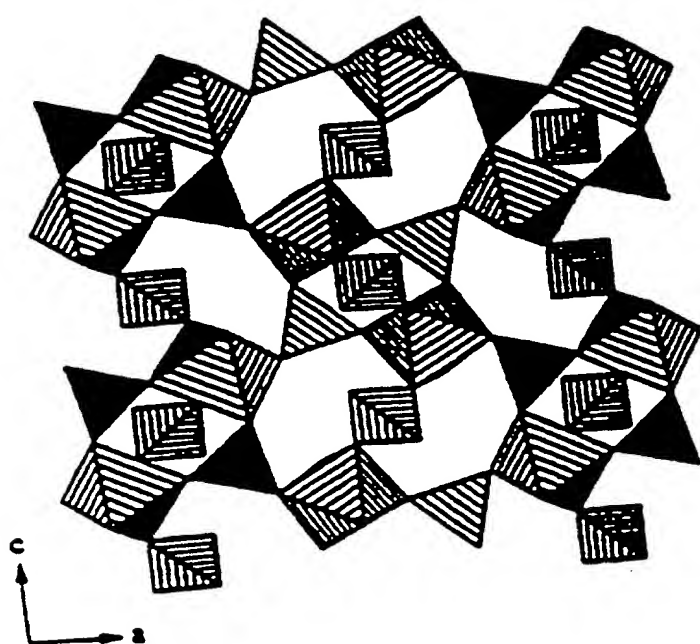


FIG. 5B

9/15

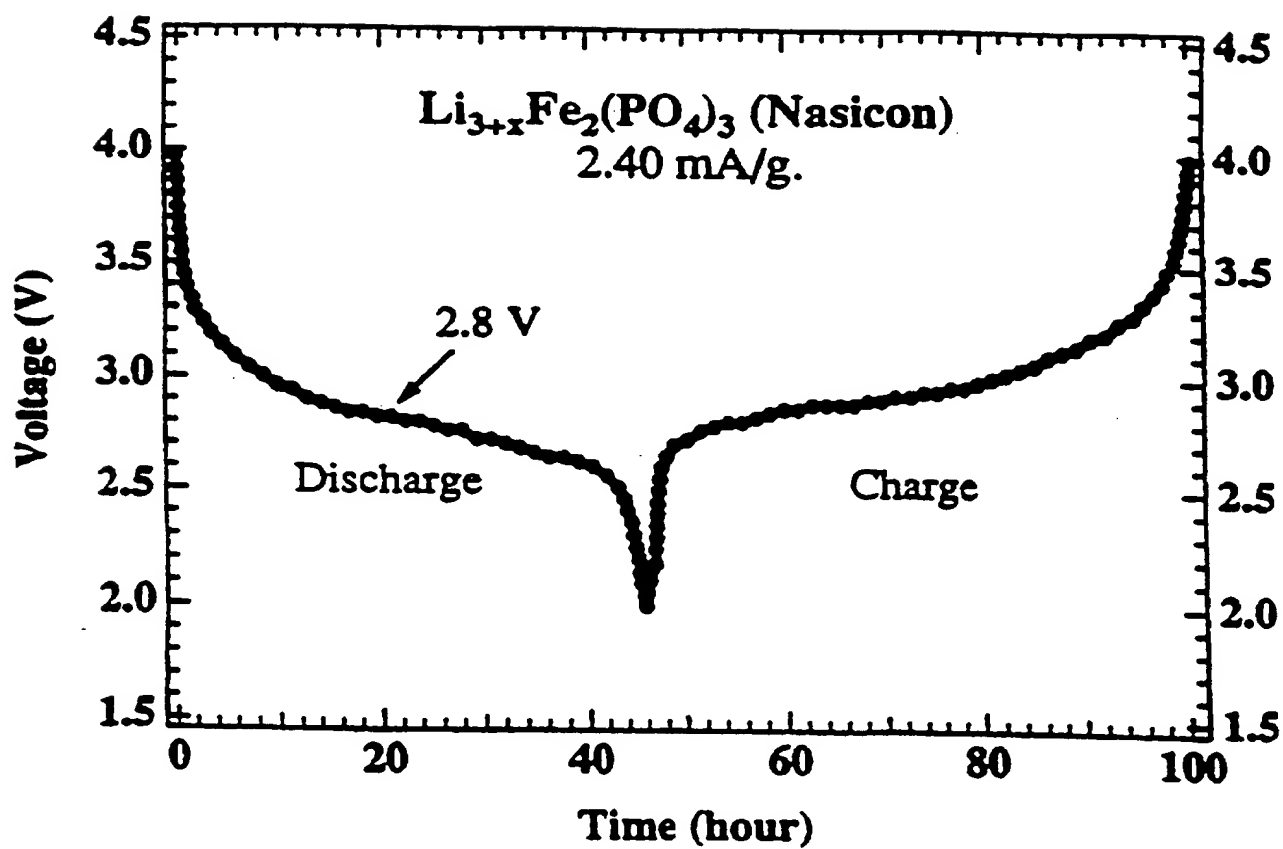


FIG. 6A

10/15

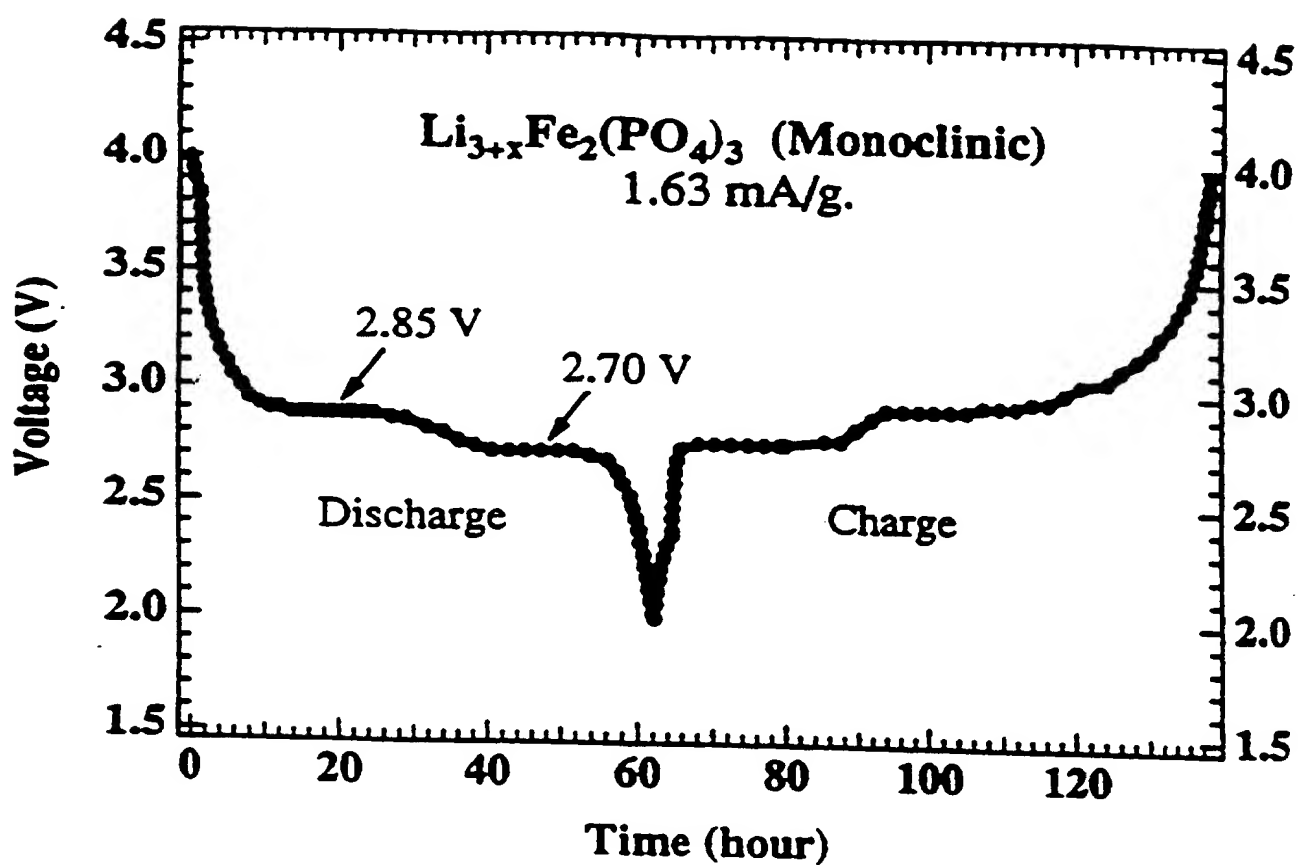


FIG. 6B

11/15

PCT/US97/06671

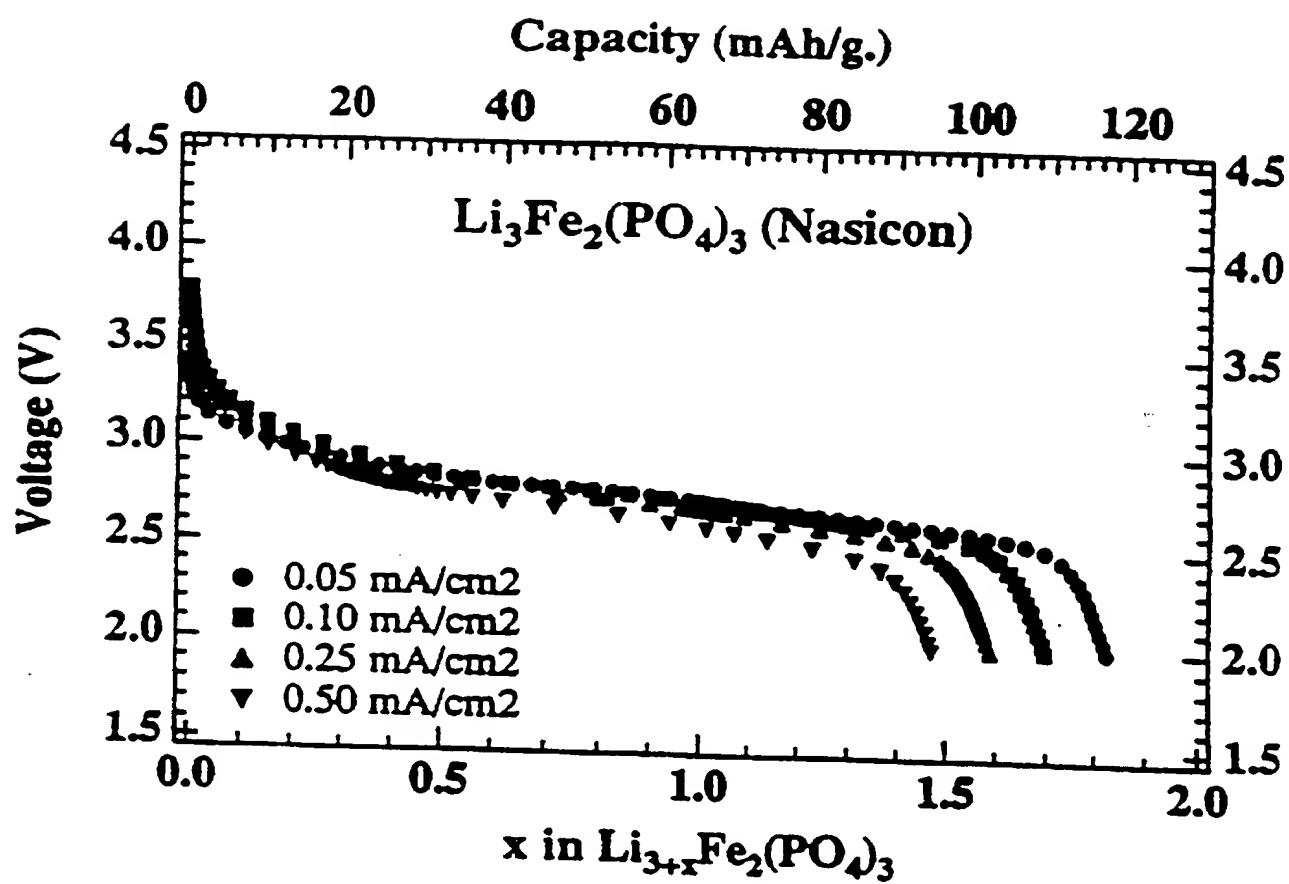


FIG. 7A

12/15

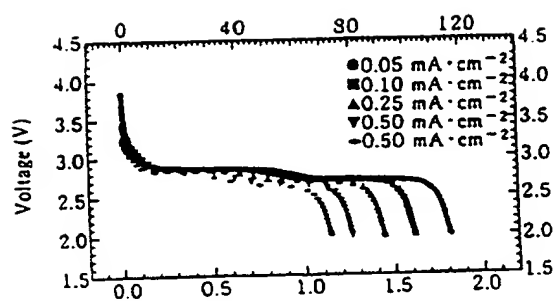


FIG. 7B

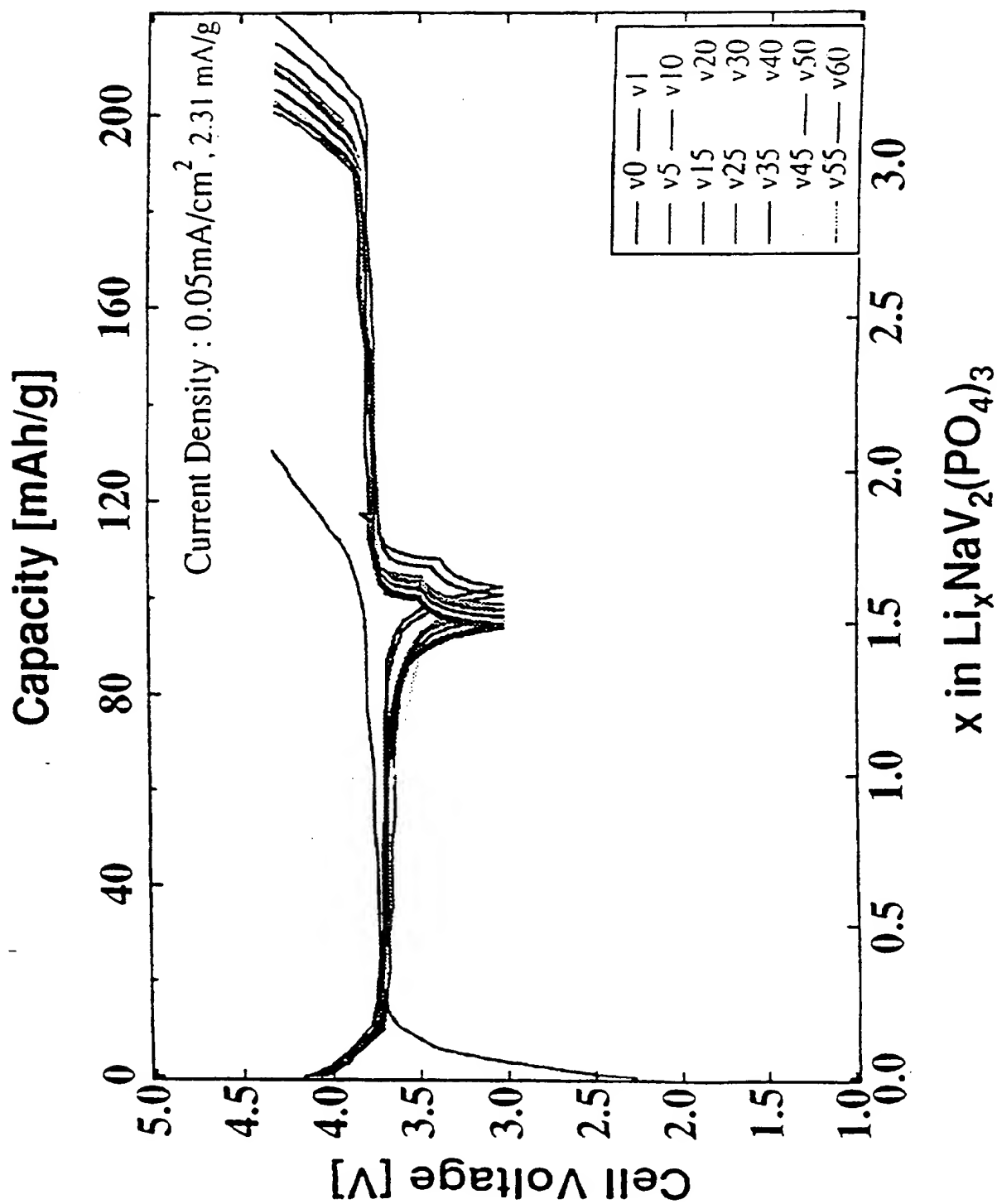


FIG. 8

14/15

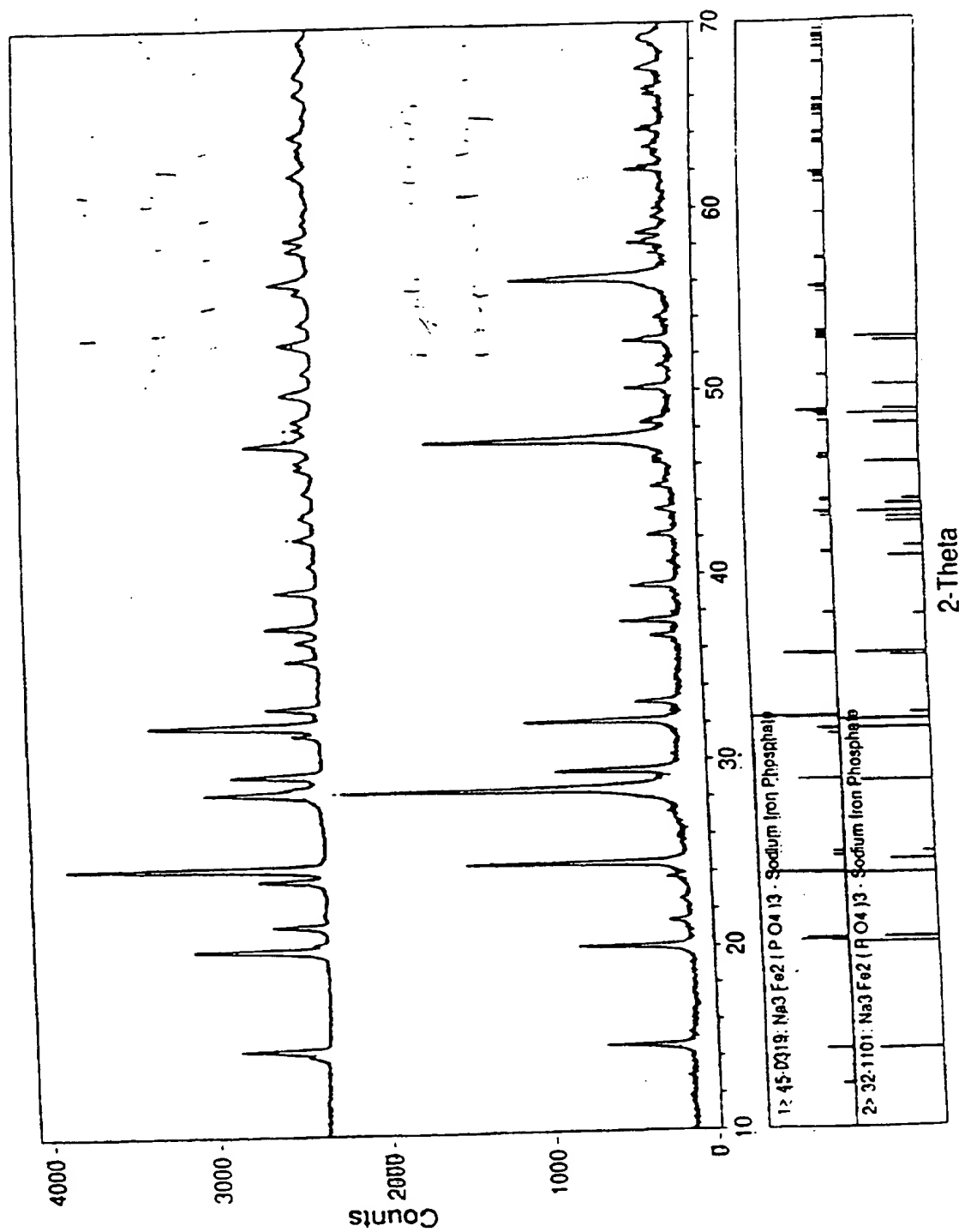


FIG. 9

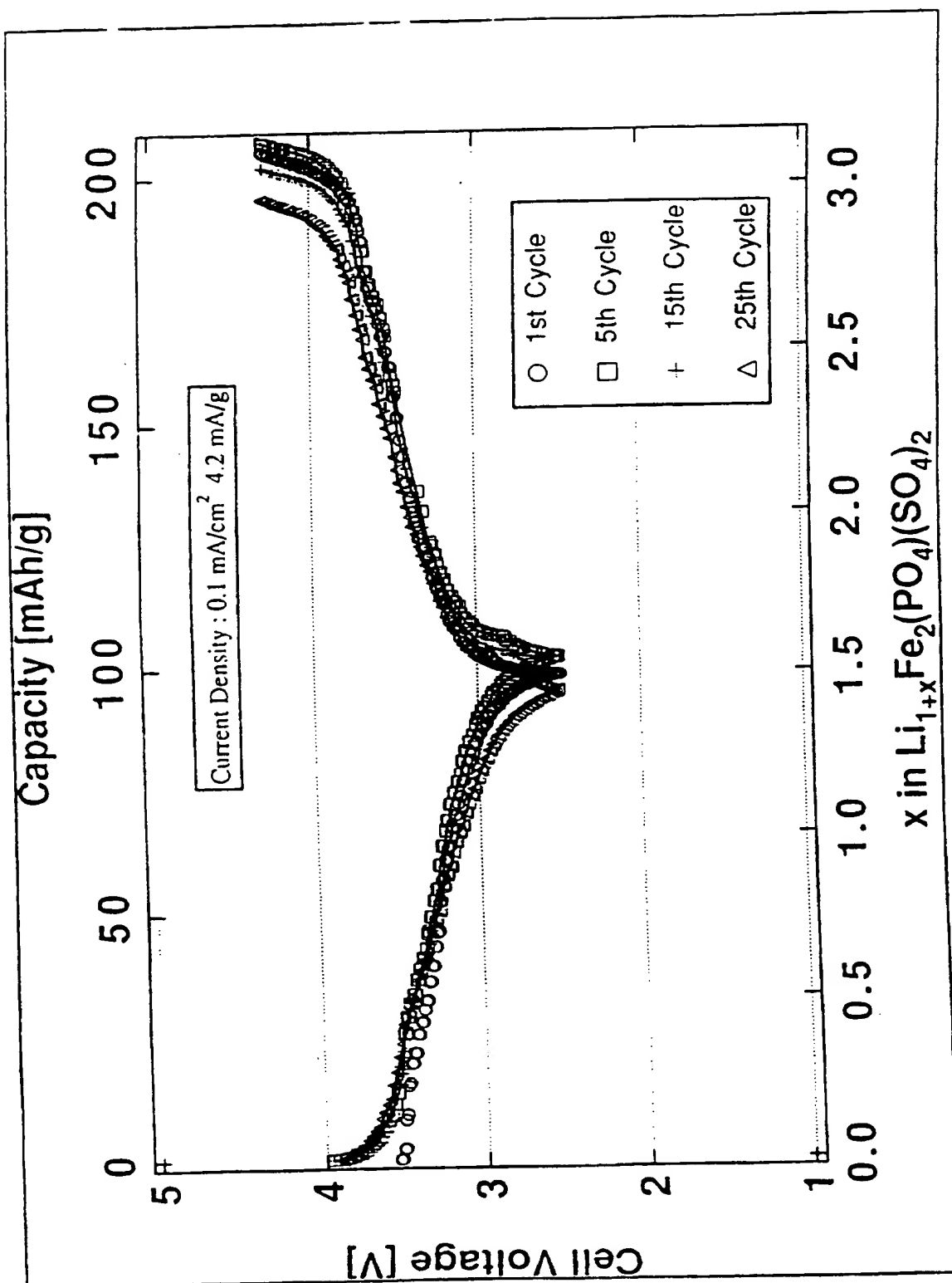


FIG. 10

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US97/06671**A. CLASSIFICATION OF SUBJECT MATTER**

IPC(6) :H01M 4/58; C01B 25/26

US CL :429/220; 423/306

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 429/220, 218, 221, 223, 224; 423/306

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched
NONEElectronic data base consulted during the international search (name of data base and, where practicable, search terms used)
NONE**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 4,985,317 A (ADACHI ET AL.) 15 January 1991, abstract and column 2, lines 36-43.	6, 7, 10, 11, 14, 15
A	US 4,465,747 A (EVANS) 14 August 1984	NONE
A, P	US 5,514,490 A (CHEN ET AL.) 07 May 1996	NONE




Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:	*T later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
*A document defining the general state of the art which is not considered to be of particular relevance	*X document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
*E earlier document published on or after the international filing date	*Y document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
*L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	*Z document member of the same patent family
*O document referring to an oral disclosure, use, exhibition or other means	
*P document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search 29 JULY 1997	Date of mailing of the international search report 29 AUG 1997
Name and mailing address of the ISA/US Commissioner of Patents and Trademarks Box PCT Washington, D.C. 20231 Facsimile No. (703) 305-3230	Authorized officer  JOHN S. MAPLES Telephone No. (703) 308-0661

Form PCT/ISA/210 (second sheet)(July 1992)*

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US97/06671

Box I Observations where certain claims were found unsearchable (Continuation of item 1 of first sheet)

This international report has not been established in respect of certain claims under Article 17(2)(a) for the following reasons:

1. ☐ Claims Nos.:
because they relate to subject matter not required to be searched by this Authority, namely:

2. ☐ Claims Nos.:
because they relate to parts of the international application that do not comply with the prescribed requirements to such an extent that no meaningful international search can be carried out, specifically:

3. ☐ Claims Nos.:
because they are dependent claims and are not drafted in accordance with the second and third sentences of Rule 6.4(a).

Box II Observations where unity of invention is lacking (Continuation of item 2 of first sheet)

This International Searching Authority found multiple inventions in this international application, as follows:

Please See Extra Sheet.

1. ☒ As all required additional search fees were timely paid by the applicant, this international search report covers all searchable claims.
2. ☐ As all searchable claims could be searched without effort justifying an additional fee, this Authority did not invite payment of any additional fee.
3. ☐ As only some of the required additional search fees were timely paid by the applicant, this international search report covers only those claims for which fees were paid, specifically claims Nos.:

4. ☐ No required additional search fees were timely paid by the applicant. Consequently, this international search report is restricted to the invention first mentioned in the claims; it is covered by claims Nos.:

Remark on Protest

- ☐ The additional search fees were accompanied by the applicant's protest.
☐ No protest accompanied the payment of additional search fees.

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US97/06671

BOX II. OBSERVATIONS WHERE UNITY OF INVENTION WAS LACKING

This ISA found multiple inventions as follows:

This application contains claims directed to more than one species of the generic invention. These species are deemed to lack Unity of Invention because they are not so linked as to form a single inventive concept under PCT Rule 13.1. In order for more than one species to be searched, the appropriate additional search fees must be paid. The species are as follows:

Species A: LiMPO_4

Species B: $\text{Y}_x\text{M}_x(\text{PO}_4)_3$

Species C: $\text{Y}_x\text{M}_x(\text{PO}_4)_x(\text{XO}_4)_{3-x}$ (where Y is not equal to 3)

Species D: $\text{A}_{3-x}\text{V}_3(\text{PO}_4)_3$ (where A is a combo of Li and Na)

The claims are deemed to correspond to the species listed above in the following manner:

Species A: claims 1-5 and 23-26

Species B: claims 6-16, 19, 21, 22, 27-33 and 36

Species C: 16-18 and 34-35

Species D: 19-22 and 36-37

The following claims are generic: None

The species listed above do not relate to a single inventive concept under PCT Rule 13.1 because, under PCT Rule 13.2, the species lack the same or corresponding special technical features for the following reasons: species C includes the XO_4 group which none of the other species contain. Species D comprises a combo of Li and Na for "A", which is absent in the other species. Species A and B include "M" and "Y" elements not encompassed by the other species and species A comprise a single PO_4 group.